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5132

DART AEROSPACE LTD	Work Order:	23350
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A	Qty:	180

Page 1 of 1

RF 02/10/17

Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	CH	05.05.20	180
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: M9601			
3	MV	Machine per folio FA183 and Dwg D3067	ER	05/06/20	180
4	QC2	Inspect parts as they come off the CNC machine	CR	05/06/20	180
5	QC7	Second inspection	ML	05/06/20	180
6	MV	Deburr	FF	05/06/20	180
7	GB	Bend as per Dwg D3067	J	05.08.14	180
8	QC5	Inspect work to Step 7	ML	05/08/15	180
9	WA	Identify and stock	J	05.08.15	180
10	AC	Cost / Part 1,00	SAC	05.08.02	180
11	DC	Close W/O 1,11 Inspect level 21	RF	05/08/15	180

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	J
C1	03.01.21	Remove step 6 (Deburr)	RF	J

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23350
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>Eg</i>	Audited by:	<i>JNL</i>	Prototype Approval:	<i>N/A</i>
Date:	05/06/07	Date:	05/06/07	Date:	03.10.07

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	AP

RELEASED
03.10.07

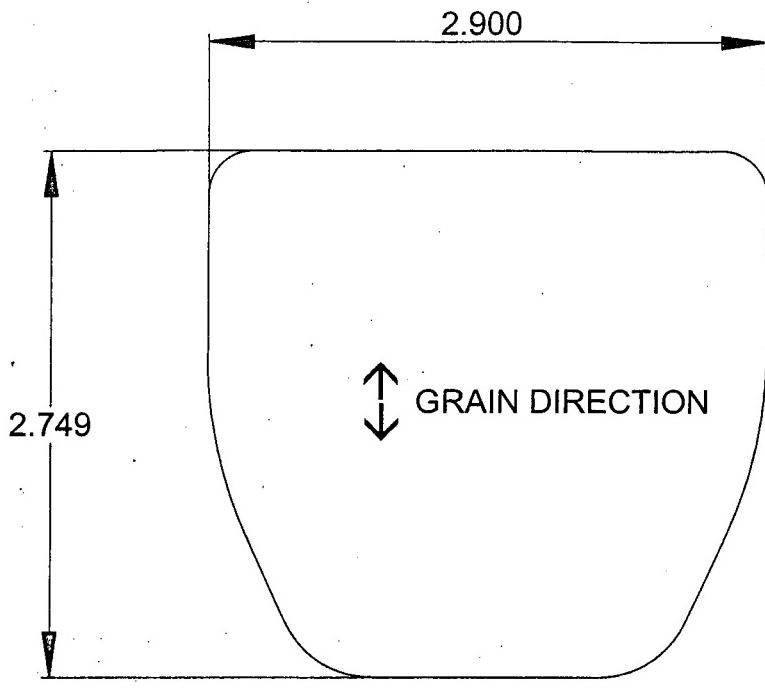


COPY ISSUED

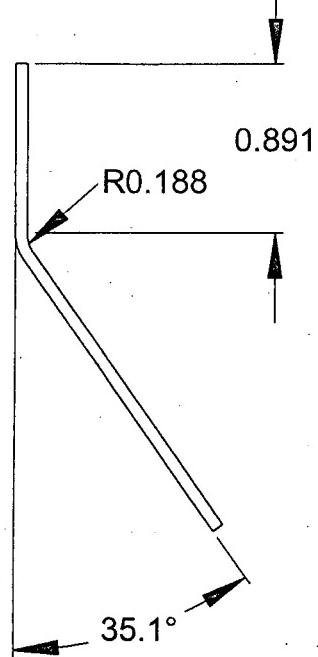
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	02.09.11	TITLE	SHEET 1 OF 1 1:1 END PLATE

RELEASED
02.04.2011

A 02.09.11 NEW ISSUE



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY

RETURN TO
ENGINEERINGUNCOPIED - COPY
SUBJECT TO APPROVAL
BY ENGINEERING

WORK ORDER

NO. 23350

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No	:	0023350	Department Code:
Project Name	:	D3067-1	Burden Flags : NNNNNNN
Project For	:	WK532	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3067-1	Invoice Number :
Description	:	End Plate	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	160	
Amount Done	:	0	Order Entry No :
Start Date	:	05-17-05	OE Value : 0.00
Est Finish Date	:	06-30-05	
Act Finish Date	:		Est Mark Up : 0.000%
Drawings Reqd	:	No	Actual Mark Up : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
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Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00